

Date: Monday, 12/01/2009 2:31:07 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARPAD
Job Number :	44579		
Estimate Number :	10700		
P.O. Number :		Part Number :	D34291
This Issue :	12/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3429 REV A
First Issue :	/ /	Project Number :	N/A
Previous Run :	44169	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	JUD 09.01.12	Due Date :	30/01/2009
Comment :	Est: A 05.10.04 New Issue KJ/EC	Qty:	20 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M1010S16GA	1010/1025 sheet 16GA
-----	------------	----------------------



Comment: Qty.: 0.1512 sf(s)/Unit Total: 3.0240 sf(s)
 1010/1025/A21/6aA steel sheet 0.063" thick
 Batch: 105706 RB 9-1-30

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3429
 Dwg Rev: A
 Prog Rev: A

RB 9-1-30



2-Deburr if necessary RB 9-1-30

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

09.01.30 (26)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 Deburr if necessary
 Form on Brake as per Dwg D3429 using Jigs DT8261 and DT8326. Identify as D3429-1
 Form Joggle as per Dwg D3429 on brake using Jig DT8158

SP 09/02/03 26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:31:07 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 44579

Part Number: D34291

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

SE *02/02/10* *326* *cont*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R 7560 Hardcoat

M109560

Weld hardcoat as per Dwg D3429

EL 9-2-12

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S *02/02/12* *(26)*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S *02/02/12* *(26)* *cont*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 109648

START TIME:

14:25

OVEN TEMPERATURE:

320°

FINISH TIME:

14:55

BR 09-02-12

(26)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-13 *(26)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *EP-17*

HS *09-02-13* *(26)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:31:08 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 44579

Part Number: D34291

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/17 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-02-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>W4519</u>
Description: Wearpad		Part Number: D3429-1
Inspection Dwg: D3429	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.220 x 0.300	+/-0.010	227 X 307	X			
1.965	+/-0.010	1.969	X			
2.715	+/-0.010	2.717	X			
3.500	+/-0.010	3.502	X			
5.859	+/-0.010	5.860	X			
.063	+/- .010	.1058	X			

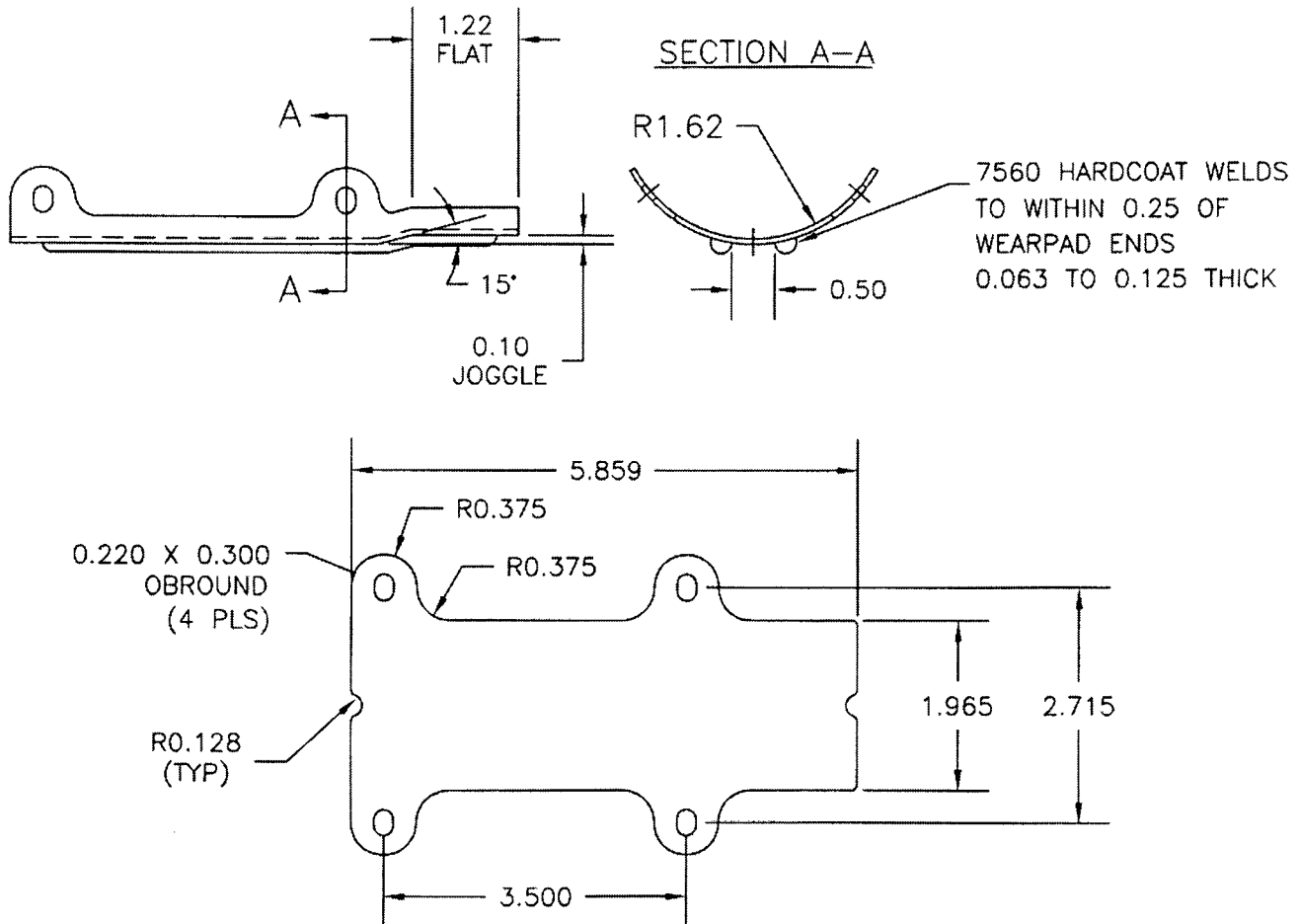
Measured by: <u>IB</u>	Audited by: <u>[Signature]</u>	Prototype Approval:	N/A
Date: <u>9-1-30</u>	Date: <u>09.01.30</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.06.24	New Issue	KJ/DD <u>[Signature]</u>	<u>[Signature]</u>

DART

DESIGN CP		DRAWN BY CP		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D3429	REV. A SHEET 1 OF 1
DATE 05.04.18				TITLE WEARPAD	SCALE 1:2
A	05.04.18		NEW ISSUE		

05.09.06

**D3429-1 WEARPAD**

- 1) BREAK ALL SHARP CORNERS 0.063 MAX
- 2) MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
- 3) FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 14579

Copyright © 2005 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.